

Work Order ID 125773

125773

Page.1

Wednesday, October 22, 2014 12:34:47 PM

Item ID: D3651-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Base Assembly
 Start Date: 10/21/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/21/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-10-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3651 | Rev B ✓ | | | | | | | | |

100 Pick Kit 0.00
100 1 FF NOV 13 2014
 Packaging Memo 0.00
 Packaging

110 Small Fab 0.00
110 1 FF NOV 13 2014
 Small Fab Memo 0.00
 Small Fab 1-Assemble as per dwg D36512- Seal all mating surfaces and gaps using
 Proseal 700 fire wall sealant as per dwg D3651Batch: M1306085 install
 D3651-1 using 3M high per formance contact adhesive 1357 as per dwg
 D3651Batch: M105623

120 QC5- Inspect part completeness to step on W/O 0.00
120 DAS
 QC Memo 0.00 30
 Quality Control 9-89 14/11/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 125773***125773***

Page 2

Wednesday, October 22, 2014 12:34:47 PM

Item ID: D3651-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Base Assembly

Start Date: 10/21/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-------------------------------------------------|----------------------|---------|--------|-------------------|---------------|---------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location: <u>GA</u> | 0.00 | | | DAS 30 9-89 | 1 | | | 14/11/13 |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | 14/11/17 JJ |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-11-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
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| Transport | | | | | | | | | |
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FAULT CATEGORY

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Picklist Print

Wednesday, October 22, 2014 12:34:46 PM

Page 1

Work Order ID: 125773

125773

Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| CR3523-4-02 | | Purchased | | No | | 100 | Each | 1,000.000 | 58 | 58 | | | |
| *CR3523-4-02* | | | | | | | | | ** | | FF | NOV 13 2014 | |
| RIVET | | | | | | | | | | | | | |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | ST317 | | | 1000 | | | | | |
| | | | | | m130415 | | | 1000 | | 58 | | | |
| D3651-043 | | Manufactured | | No | | 110 | Each | 7.0000 | 1 | 1 | | | |
| *D3651-043* | | | | | | | | | ** | | FF | NOV 13 2014 | |
| Flange Weldment | | | | | | | | | | | | | |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | ST207 | | | 7 | | | | | |
| | | | | | 94016 | | | 7 | | 1 | | | |
| D3651-1 | | Manufactured | | No | | 110 | Each | 10.0000 | 1 | 1 | | | |
| *D3651-1* | | | | | | | | | ** | | FF | NOV 13 2014 | |
| Gasket | | | | | | | | | | | | | |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | ST506 | | | 10 | | | | | |
| | | | | | 95811 | | | 10 | | 1 | | | |
| D3651-11 | | Manufactured | | No | | 110 | Each | 4.0000 | 1 | 1 | | | |
| *D3651-11* | | | | | | | | | ** | | FF | NOV 13 2014 | |
| Gasket | | | | | | | | | | | | | |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | st507 | | | 4 | | 1 | | | |
| | | | | | 94796 | | | 4 | | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
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| Equip/Tooling | | | | | | | | | |
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Picklist Print

Page 2

Wednesday, October 22, 2014 12:34:46 PM

Work Order ID: 125773

125773

Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

D3651-13 Manufactured No

110 Each 10.0000 1 1

D3651-13

Outside Doubler

FF NOV 13 2014

Location

Loc Qty

Loc Code

st507

10

94690

1

95404

9

D3651-9 Manufactured No

110 Each 3.0000 1 1

D3651-9

Inside Doubler

FF NOV 13 2014

Location

Loc Qty

Loc Code

ST506

3

95376

3

Wednesday, October 22, 2014 12:34:47 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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